



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79395

**\*79395\***

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January-25-12 12:48:07 PM

Item ID: D2873-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Nut Plate Assembly  
 Start Date: 25/01/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 08/02/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	<i>DA</i>	<i>12/2/4</i>		<i>20</i>	<i>0</i>		
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00 0.00							<i>EP 12/02/06 20</i>
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	<i>8.2/02/06</i>			<i>20</i>			<i>100%</i>

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*160*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
<b>*180*</b>									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-043								

*20 BL 1226*

*20x4 M/L 12/02/06*

*EP 12/02/08 (20)*

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*79395\***

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January-25-12 12:48:07 PM

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				counts (720)			
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>LG</u>  Memo	0.00  0.00				12 - 2 - 9 (20)			
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				M.L.J 12/02/09			

M.L.J 12/02/09  
 (20)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 79395

\*79395\*

Parent Item: D2873-043

\*D2873-043\*

Parent Item Name: Nut Plate Assembly

Start Date: 25/01/2012

Required Date: 08/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5 *MS21075L 5* Nut Plate		Purchased	No			100	Each	26.0000	3	60		12/02/08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST302		25							
				119414		25							
				ST303		1							
				116914		1							
M6061T6B0.375X01.00 0 *M6061T6B0 375X01 000* 6061T6 BAR .375 x 1.00		Purchased	No			180	f	25.5200	0.3083	6.490526		12/02/01	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT001		13.52							
				118641		13.52							
				MAT002		12							
				119346		12							
MS20426AD4-6 *MS20426AD4-6* Rivet		Purchased	No			180	Each	1,343.000	6	120		12/02/08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST317		1343							
				110139		207							
				117505		136							
				119436		1000							

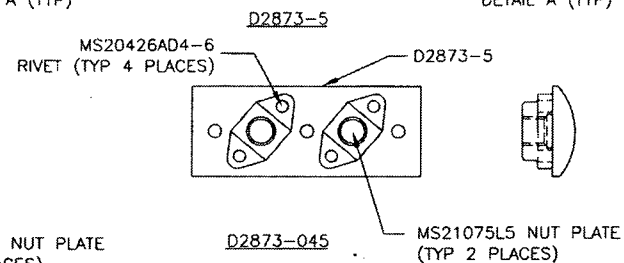
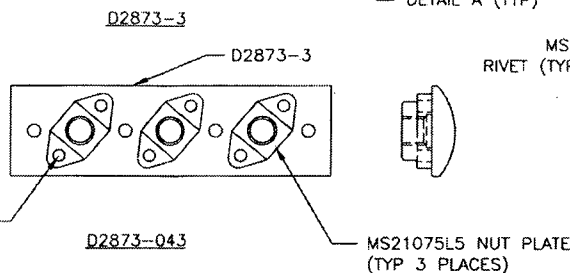
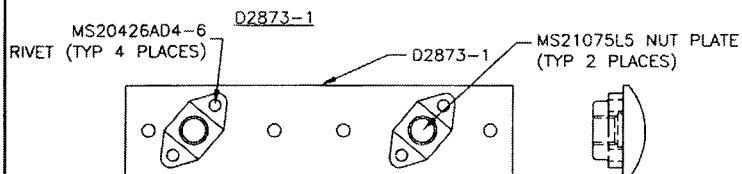
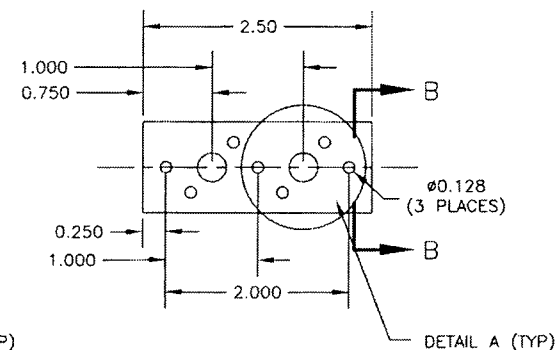
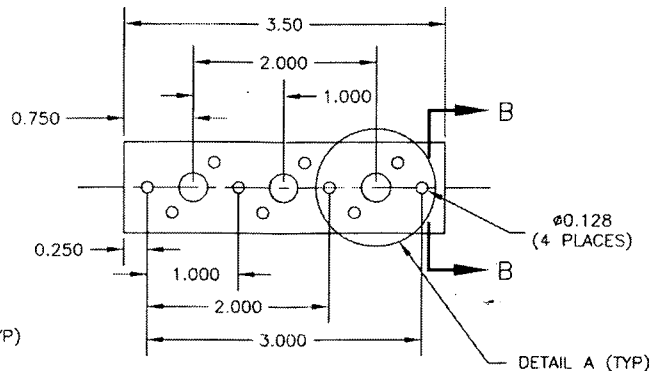
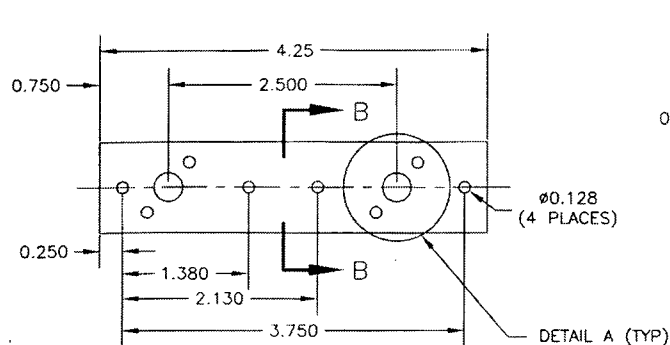
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D2873-041

**D2873-1/-3/-5 RADIUS BLOCK**

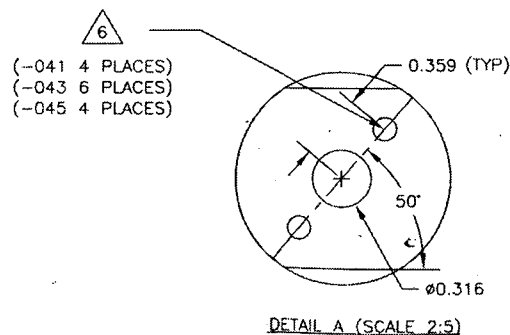
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

**D2873-041/-043/-045 NUT PLATE ASSEMBLY**

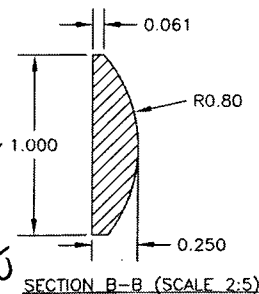
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

**D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



SHOP COPY  
RETURN TO  
ENGINEERING  
FOR REVIEW  
REVISION  
NOTICE  
WORK ORDER  
79395-MCJ  
12/01/25



RELEASED  
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED DS	APPROVED DS	DART AEROSPACE LTD HUNTSBURY, ONTARIO, CANADA
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A D2873 SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Radius Block		<b>Part Number:</b>	D2873-3
<b>Inspection Dwg:</b> D2873 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓		Verif. SLO8	
2.000	+/-0.010	2.000	✓		"	
0.750	+/-0.010	0.750	✓		"	
1.000	+/-0.010	1.000	✓		"	
0.250	+/-0.010	0.251	✓		"	
1.000	+/-0.010	0.9985	✓		"	
2.000	+/-0.010	1.999	✓		"	
3.000	+/-0.010	2.9995	✓		"	
Ø0.128	+0.005/-0.001	Ø0.1305	✓		"	
0.359	+/-0.010	0.361	✓		"	
Ø0.316	+0.006/-0.001	Ø0.317	✓		"	
1.000	+/-0.010	1.000	✓		"	
0.250	+/-0.010	0.2525	✓		"	
0.061	+/-0.010	0.063	✓		"	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.232 x .125	✓		"	

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12/02/02	<b>Date:</b> 12/2/04	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue      P/O D2873-043	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>